

Date: Friday, 06/03/2009 8:50:39 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 46315	
Estimate Number : 11040	
P.O. Number :	Part Number : D28042
This Issue : 06/03/2009 S.O. No. :	Drawing Number : D2804 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 44476	Material :
Written By :	Due Date : 13/03/2009 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est. A00.11.06 New Issue EC	
Est. B06.05.30 Blanks on wjetEC	
Est Rev:C As per Rev C 06-11-09 JLM	
Est Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00
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Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 109253

ml 09 03 06 (10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

ml 09 03 06 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

mmf 09/03/11

(9)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/03/11

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2804-2 PAR #: N/A Fault Category: Prod / Machined Part NCR: (Yes) No DQA: D Date: 09/03/13
 Resolution: D412-430 SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/16

NCR: <u>46315</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.11	3	Depth of slot for Stopper is 0.258 on one part. Qty(1) affected	CP 09.03.11 per QSI 042	Scrap part.	mmw 09/03/11	<u>/</u> 09.03.13	CP 09.03.11 per QSI 042	<u>/</u> 09.03.13

NOTE: Date & initial all entries

Date: Friday, 06/03/2009 8:50:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 46315

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 09/03/12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMD / BR

09/03/12

(X9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/03/12

(9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 157A

9/3/12

SEP

(9X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 09/03/13

MF 09-03-13

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4635
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

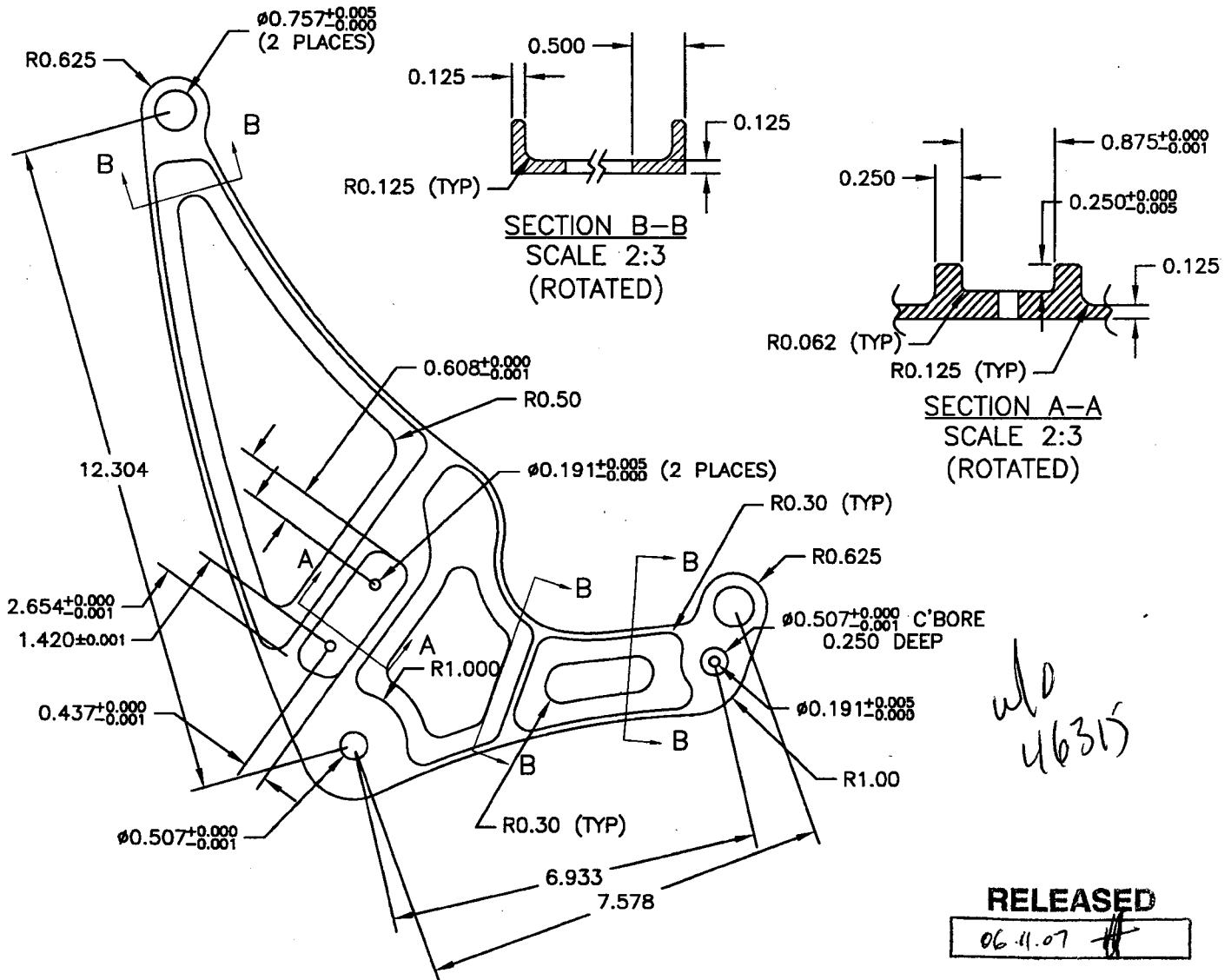
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.130	✓			
0.125	+/-0.010	.125	✓			
R0.125	+/-0.010	R.125	✓			
0.250	+/-0.010	.250	✓			
0.250	+0.000/-0.005	.248	✓			
0.875	+0.000/-0.001	.875	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.757	+0.005/-0.000	Ø.757	✓			
R0.625	+/-0.010	R.625	✓			
12.304	+/-0.005	12.303	✓			
Ø0.507	+0.000/-0.001	Ø.507	✓			
0.437	+0.000/-0.001	.437	✓			
0.608	+0.000/-0.001	.608	✓			
Ø0.191	+0.005/-0.000	Ø.192	✓			
1.420	+0.001/-0.001	1.419	✓			
0.250 deep	+/-0.010	.250	✓			
6.933	+/-0.005	6.930	✓			
7.578	+/-0.005	7.577	✓			
0.500	+/-0.010	.500	✓			

Measured by: mmf	Audited by: SP	Prototype Approval:	N/A
Date: 09/03/11	Date: 09/03/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	BE

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16			TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

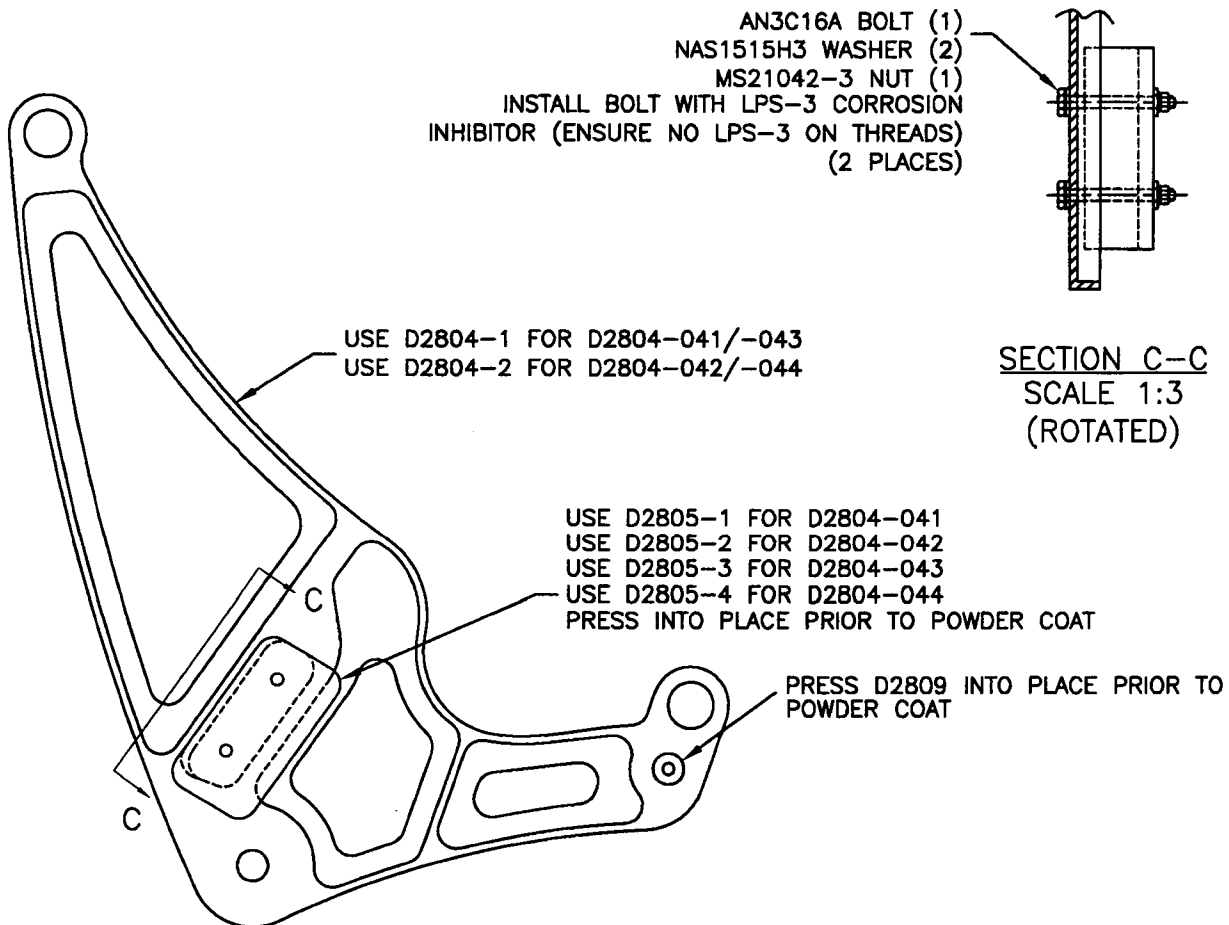
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

**RELEASED**

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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